

Addendum & Corrigendum Slip No. 1 of September, 2023

To

Manual for Glued Insulated Rail Joints (First Reprint-2022)

1. Para 0.4 of the Manual is replaced with the following.

There are two types of glued joints namely **G3 (L)** type having six bolts and **G3(S)** type having four bolts. G3(L) type and G3(S) type of glued joints can be manufactured from different rail sections as per drawing numbers given below: -

End post Thickness	Rail Section	Drawing No.	
		G3(L) Type	G3(S) Type
6 mm	1. 75R	RDSO/T-1283	RDSO/T- 3008
	2. 90R	RDSO/T- 1276	RDSO/T-1278
	3. 52 Kg	RDSO/T- 671	RDSO/T- 1259
	4. 60E1/60 Kg (UIC)	RDSO/T- 2572	RDSO/T-2576

2. (1) Para 4.5 shall be reworded as under:

4.5 (a) Renewal/replacement of glued joints shall be done on condition basis as prescribed in para 702(1) (f) of IRPWM, 2020.

4.5 (b) For the purpose of calculating requirement of glued joints for sanction etc. tentative life of insulated glued joints may taken as:

(i) 60kg/60E1 rail section with 6mm thick end post - 400GMT.

(ii) For 52kg rail section with 6mm thick end post. - 200GMT.

(2) Para 5.3- is deleted

3. Para C.5.4.1, (Annexure-C) of Manual is replaced with the following.

Quantity of raw material required for insulating components for 52kg G3(L) and 60kg/60E1 G3(L) glued joint, with 6mm thick end-post drawing, shall be approximately as under:

S. No	Insulating Components	Qty. reqd. per joint	Fibre Glass cloth (gm)		Epoxy resin (gm)		Hardener (gm)	
			52kg	60kg/60E1	52kg	60kg/60E1	52kg	60kg/60E1
1.	Insulating Liners	2	500	560	450	500	45	50
2.	End post	1	125	135	105	108	11	11
3.	Bushes/ Sleeves	6	25	36	30	31	3	3